

## ABSTRACT

A controlling member (a controlling pin 10) is inserted through an insertion hole 7 of a mold 1 and projected into a cavity 6. After a pipe P as an insert member is arranged at a predetermined position in the cavity 6, the pipe P is held in the cavity 6 by inserting a tip of the controlling pin 10 into a hole h of the pipe P at the end p<sub>1</sub>, or by inserting the end p<sub>1</sub> of the pipe P into a cave 21 of the controlling member. A molten aluminum alloy is then poured through a gate 5 into the cavity 6 under such the condition, to enclose the pipe P with the aluminum alloy. Dislocation of the pipe P caused by kinetic and thermal energies of the poured aluminum alloy is suppressed by the controlling pin 10 or block 20 at the end p<sub>1</sub>. Since the enclosed pipe P has its end p<sub>1</sub> opened at a predetermined position, a cast product obtained in this way can be used as a brake caliper or the like having an inner hydraulic circuit.